



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G11151-3G

Job Sheet 188396



Part No: RBW6305G11151-3G

Job Qty: 12 pcs

Part Name: Pin, Main Rotor Servoactuator Fitting Installation



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G11151-3G Rev. 2 IPP Rev. A 18.05.18 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Bandsaw - 1	6 pcs	3/8/19	3/8/19	0.00	0.30	Bandsaw - 1		
120	SL-154 - B4B	6 pcs	3/8/19	3/8/19	0.00	4.20	SL-154 - 1 - B4B		
130	QC 2	6 pcs	3/8/19	3/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S158371



Part: RBW6305G11151-3G

Job No: 188396

Serial No/Batch: S158371

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/02/19

140 QC 8	6 pcs	3/8/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	mk 19/03/05
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
170 Outsource - 13 - Zinc Plating	6 pcs	3/8/19		GRO002-VC	10 PL 03/04/2019
180 Packaging 2-1 - Receive - B4B	6 pcs	3/8/19	0.00 0.00	Packaging 2 - 1 - B4B	
12 pcs DP				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	JP MAR 13 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	

190	QC 6	6 pcs	3/8/19	0.00 0.00	QC 6 - 38	
					QC 6 - 42	
					QC 6 - 9	DAS
					QC 6 - 68	MAR 13 2018
					QC 6 - 61	9-89
200	Packaging 3-1 - Stock - B4B	6 pcs	3/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
210	QC 21 - SA	6 pcs	3/8/19	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-89

MAR 14 2018

Part Op 110 - Bandsaw1 (Bandsaw)
 Descriptions: 120 - SL-154 (MORI SL-154 LATHE) 1-Machine as per DWG. FC _____ FOLIO REV: _____ DWG REV: _____
 2-Debur
 130 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)
 140 - QC8 Machining-4 (QC8- Inspect parts - second check) Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 170 - -Issue P/O to GROUPE ALTECH: P/O 042618 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 1018 -Certificate of Conformity is required
 180 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)
 190 - QC6 (QC6- All purchased or subcontracted products)
 200 - Packaging3-1 (Identify as per dwg & Stock Location: _____)
 210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.500	1018-1025 round bar .500	1.4760 ft (.246 ea)	110-Bandsaw - 1	549552

1246

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Bandsaw - 1	M1018R0.500	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 1/25/19 10:37 AM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G11151-3G

Job Sheet 188396



Part No: RBW6305G11151-3G

Job Qty: 1 ea

Part Name: Pin, Main Rotor Servoactuator Fitting Installation



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G11151-3G Rev. 2 IPP Rev. A 18.05.18 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/8/19	3/8/19	0.00	0.00	Start Up Machining-3		
110	Bandsaw	2 pcs	3/8/19	3/8/19	0.00	0.10	Bandsaw1		
120	CNC Lathe	2 pcs	3/8/19	3/8/19	0.00	1.40	SL-154		
130	QC	2 pcs	3/8/19	3/8/19	0.00	0.00	QC2 Machining-4		
140	QC	2 pcs	3/8/19	3/8/19	0.00	0.00	QC8 Machining-4		
170	Outsource	2 pcs	3/8/19	3/8/19			GRO002-VC	10	
180	Packaging	2 pcs	3/8/19	3/8/19	0.00	0.00	Packaging2		
190	QC	2 pcs	3/8/19	3/8/19	0.00	0.00	QC6		
200	Packaging	2 pcs	3/8/19	3/8/19	0.00	0.00	Packaging3-1		
210	QC21-SA	2 Ea	3/8/19	3/8/19	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG. FC _____ FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 140 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
170 - Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 1018 -Certificate of Conformity is required

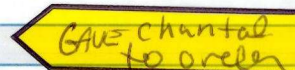
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.500	1018-1025 round bar .500	.4920 ft (.246 ea)	90-Start up Operation	S149552

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R0.500	0	0	0

Part Specifications



Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

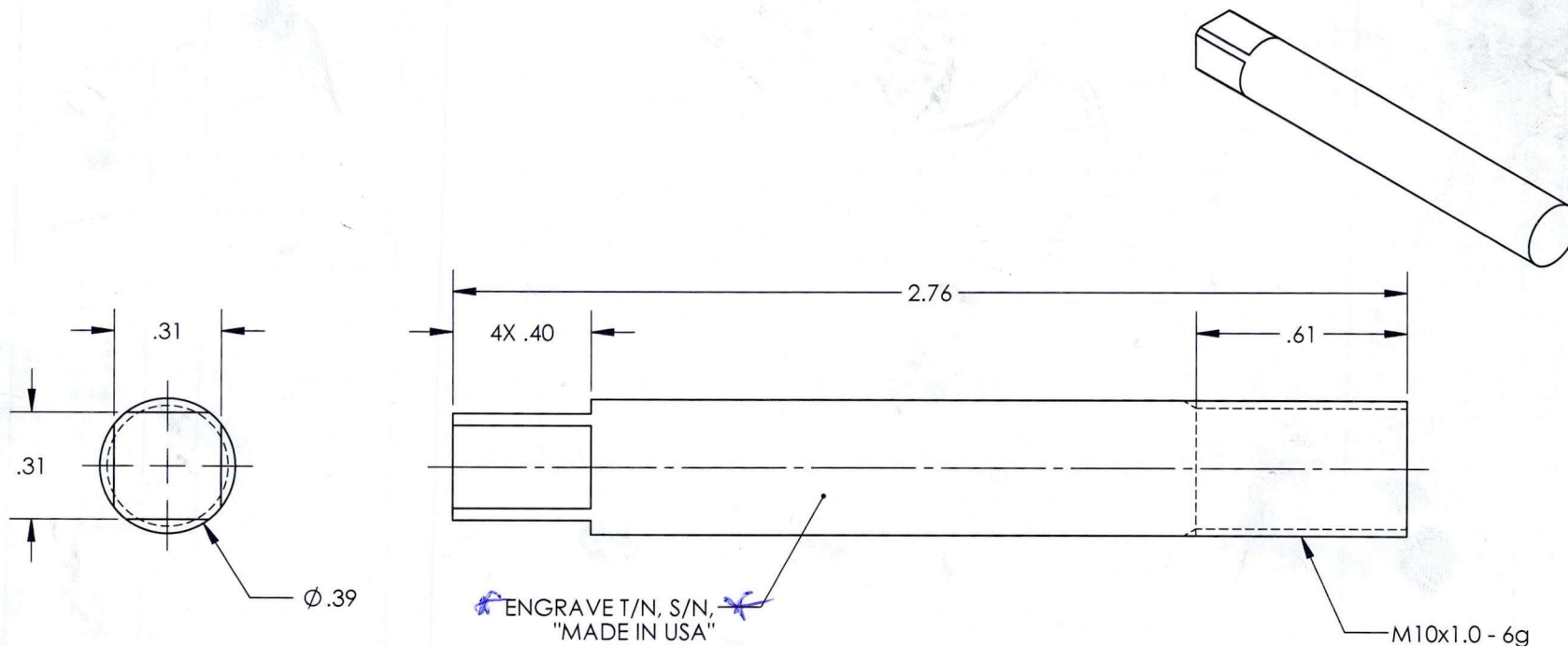
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/2/2015	DPD	JAG
2	16-0262	CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE, CH'D SPEC WAS QQ-P-416F, TYPE II, CLASS II IS ASTM B633 TYPE I SC 2, CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR, CH'D THREAD WAS M10x1.0 IS M10x1.0 - 6g.	12/5/2016	SM	JAG



NOTES:

1. REF. AGUSTA T/N: 3G6305G11151.
2. PART OF KIT: RBW6305G02831-3G.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188396 MW
1901-09

DART AEROSPACE	
TITLE PIN, M/R SERVOACTUATOR FITTING INSTL	
DWG NO. RBW6305G11151-3G	REV 2
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	AW139
APPROVED: GILBERT	
SCALE 2:1	DATE 3/10/2015 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
				1	PIN	1018/1020 CR	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042818



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042818
PO Date: 3/6/19
Due Date: 3/13/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188396	RBW6305G11151-3G	Pin, Main Rotor Servoactuator Fitting Installation -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 1018 -Certificate of Conformity is required	Firmed - X12		3/13/19	12 pcs	0 pcs	12 pcs	\$7.50/pcs	\$90.00
MAR 13 2019 DP DAS 68 9-89											
Line Item Note **Need parts back for March 13,2019**											
2	190639	RBW6405G02131-3G-5	Quarter Bell -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed - X12		3/13/19	12 pcs	0 pcs	12 pcs	\$11.25/pcs	\$135.00
MAR 13 2019 DP											
Line Item Note **Need parts back for March 13,2019**											

Plex 3/8/19 10:24 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042818



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190638	RBW6405G02131-3G-1	Bolt -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed -		3/13/19	6 pcs	0 pcs	6 pcs	\$3.00/pcs	\$18.00
Line Item Note **Need parts back for March 13, 2019**											
Grand Total:										\$243.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/19 10:24 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017480- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
11-Mar-2019		Shankar Anand				PO042818			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6305G11151-3G Rev.	RBW6305G11151-3G 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2		ZINC CH	12	12	0	0	DAS 68 9-8
2	RBW6405G02131-3G-5 Rev.	QUARTER BELL 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***		ZINC CH	12	12	0	0	0
3	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***		ZINC CH	6	6	0	0	0

DAS
68
9-89

Notes Additionnelles / Additional Notes

3 Box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.